

Work Order ID 137590

Wednesday, October 07, 2015 12:40:24 PM

137590

Page 1

Item ID: D3508-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft Center
 Start Date: 10/07/15 Start Qty: 2.00 ***Q* 6 SH** Cust Item ID:
 Required Date: 10/07/15 Req'd Qty: 2.00 ***Q* 6** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: OCT 08 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3508	Rev C

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3508 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
OCT 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							DAS 38 9-89
Quality Control									OCT 22 2015
170	Identify as per dwg & Stock Location: <u>FP002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								x6 <u>EL</u> 15/10/27
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							MCS OCT 23 2015
Quality Control									

SU 20151023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, October 07, 2015 12:40:23 PM

Work Order ID: 137590

137590

Parent Item: D3508-11

D3508-11

Parent Item Name: Wearplate Aft Center

Start Date: 10/07/15

Required Date: 10/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	297.3323	0.5887	1.239368			

M304S20GA

304/316 .040 Sheet

DC15/10/19

Location

Loc Qty

Loc Code

MAT

11.2

m131700

11.2

MAT020

286.1323

m130345

1.3139

m131060

90.2484

m132387

194.57

4.3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER :							

DART AEROSPACE LTD		Work Order:	137590
Description: Wearplate		Part Number:	D3508-11
Inspection Dwg: D3508	Rev: C	Page 1 of 1	

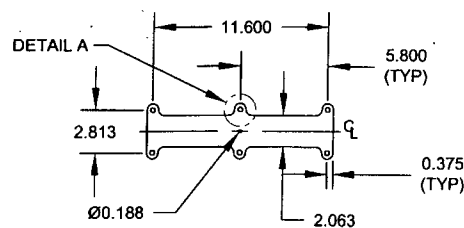
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

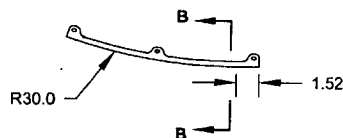
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	/		V:K-02	
2.813	+/-0.010	2.812	/		Tape	
0.375	+/-0.010	.371	/			
5.625	+/-0.010	5.626	/			
22.500	+/-0.010	22.500	/			
26.50	+/-0.030	26.50	/			
Ø0.188	+0.005/-0.001	Ø.188	/			
0.300	+/-0.010	.303	/			
0.300	+/-0.010	.303	/			
0.038	+/-0.010	.034	/			

Measured by: <i>AK</i>	Audited by: ^{DAS} 38	Prototype Approval:	N/A
Date: 15/10/19	Date: 9-89 OCT 20 2015	Date:	N/A

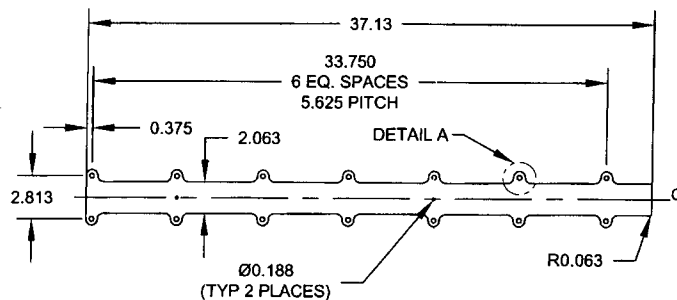
Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	<i>[Signature]</i>



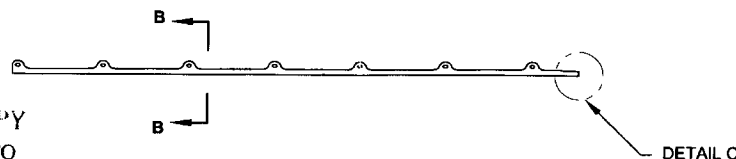
D3508-1 FLAT PATTERN



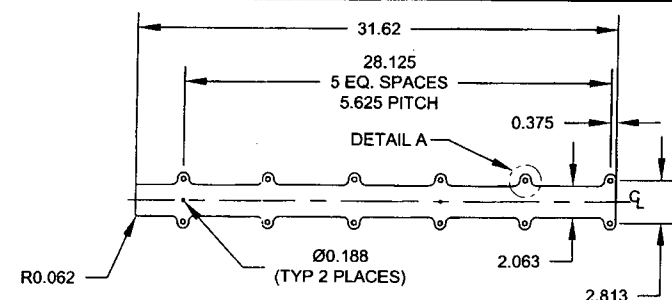
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



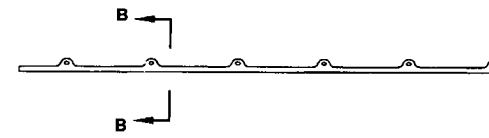
D3508-3 FLAT PATTERN



D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



D3508-5 FLAT PATTERN



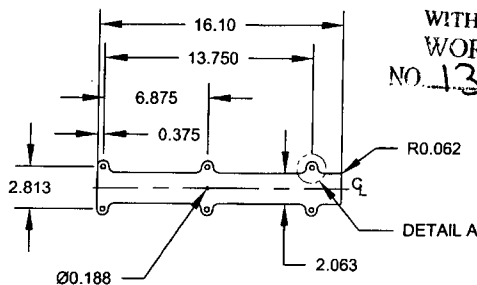
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

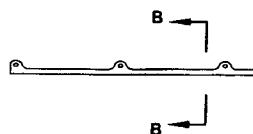
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

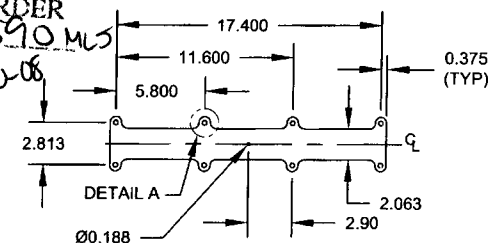
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137590 MJS
1570-08



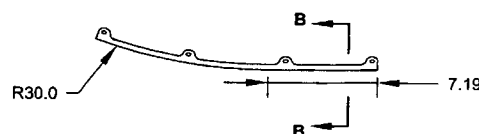
D3508-7F FLAT PATTERN



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)

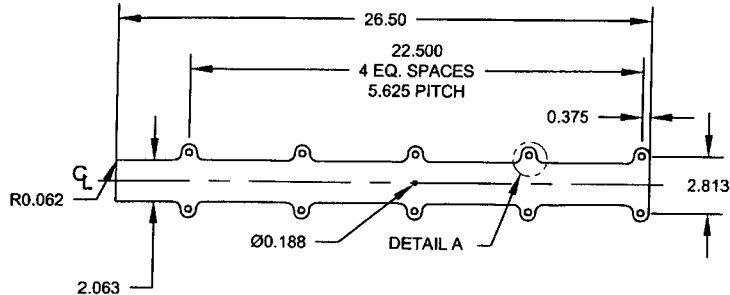


D3508-9F FLAT PATTERN

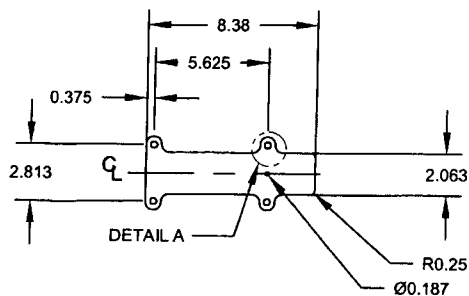


D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

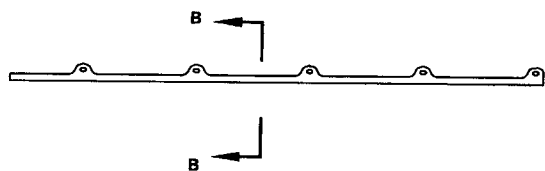
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	TITLE WEARPLATE SCALE 1:8	
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONVEYANCE THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



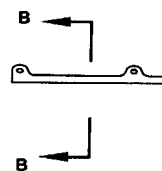
D3508-11F FLAT PATTERN



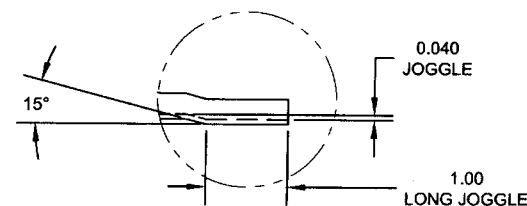
D3508-13F FLAT PATTERN



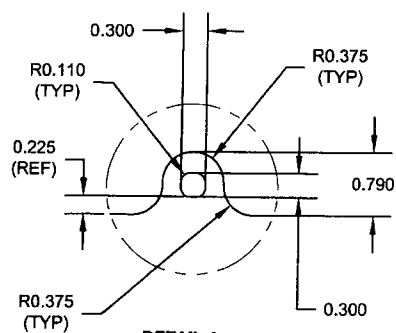
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



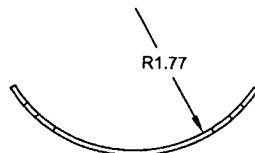
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



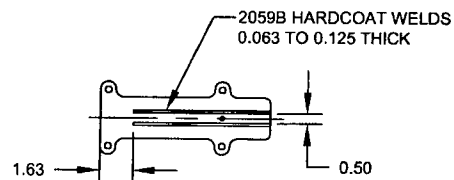
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D3508	SHEET 2 OF 2
APPROVED	WAP	TITLE	SCALE
DE APPR.	WAP	WEARPLATE	1:6
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